

Work Order ID 126060

646.3913

126060

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B 126060

Item ID: 646.3913

REV. N/C

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shim

Start Date: 10/27/14

Start Qty: 92.00

92

Cust Item ID:

Required Date: 10/28/14

Req'd Qty: 92.00

92

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

646.3900

N/C

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: N/CProg Rev: N/C

2-Deburr if necessary

DAS
23
9-89

14-10-27

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

DAS
23
9-89

14-10-27

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Reference:

Stop ***NR2***

Quality Control

DAS
38
9-89

OCT 27 2014

Outsource process - Cad plate

Issue P/O: 26 392

CY 14/11/05 92

Packaging

92x 8015-01-29

Work Order ID 126060

126060

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Item ID: 646.3913 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Shim
 Start Date: 10/27/14 Start Qty: 92.00 *92* Cust Item ID:
 Required Date: 10/28/14 Req'd Qty: 92.00 *92* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00				(82)	(10)		DAS 38 9-89
160									
QC	Memo	0.00							MAR 04 2015
Quality Control									PTO
170	Identify as per dwg & Stock Location: CC4104	0.00				82			DAS 27 5-89
170									15-03-05
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

15-3-5

Picklist Print

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Work Order ID: 126060

126060

Parent Item: 646.3913

646.3913

Parent Item Name: Shim

Start Date: 10/27/14

Required Date: 10/28/14

Start Qty: 92.00

Required Qty: 92.00

Comments: IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.032		Purchased	No			110	sf	12.0000	0.02	<u>2</u>			DAS
MC1095S 032									**	<u>2</u>			23
C1095 Blue Tempered Spring Steel Sheet .032 mcmaster p/n: 9036K507													9-89 14-10-27

Location

Loc Qty

Loc Code

MAT

12

M130477

12

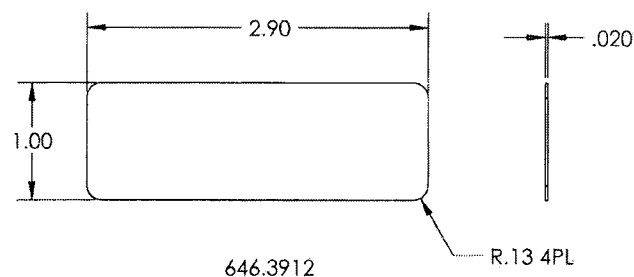
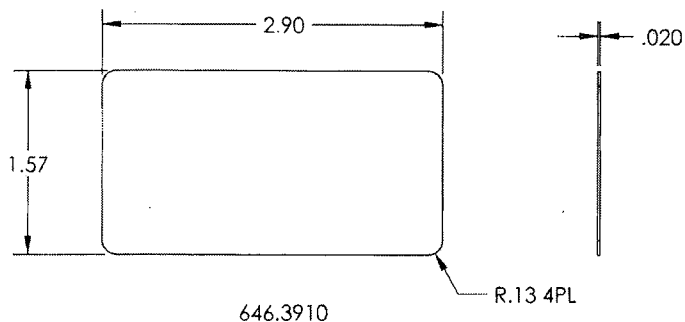
130477

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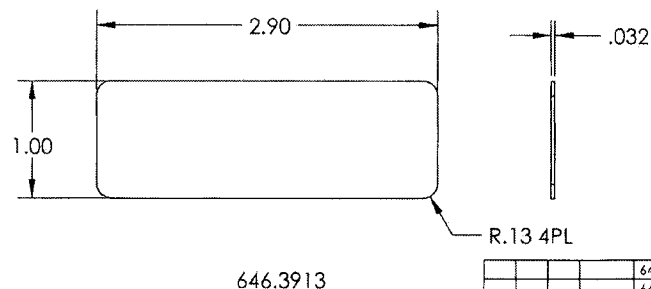
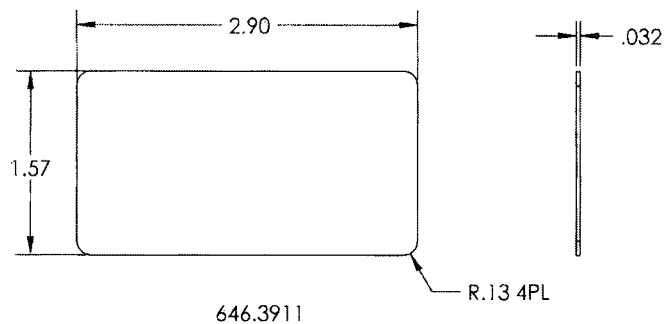
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

NOTES:

- 1 MATERIAL: SHIM STOCK, C1095 BLUE-TEMPERED SPRING STEEL
- 2 FINISH: CAD PLATE PER QQ-P-416 TYP II CL2
- 3 IDENTIFY IAW MPP-120



WLB
2/6/00



		646.3913	SHIM		
		646.3912	SHIM		
		646.3911	SHIM		
		646.3910	SHIM		
QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
PARTS LIST					
NEXT ASSY IS			APICAL INDUSTRIES		
646.4000			2608 TEMPLE HEIGHTS DR.		
			OCEANSIDE, CA. 92056-3512 (760)724-5300		
			SHIM		
			SEE CACAL CODE	DWG. NO.	REV.
			B 07M26	646.3900	N/C
			SCALE: NONE		
			SHEET 1 OF 1		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26392

Purchase Order Date 11/5/2014

PO Print Date 11/5/2014

Page Number 2 of 4

Order From :

VC-CAD002

Ship To : DART AEROSPACE LTD

CADORATH COATING
2150 LOGAN AVE.
WINNIPEG, MB R2R 0J2
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

204 633 9420

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

3	126060	646.3913 SHIM	11/21/2014	92.00	✓	\$6.60	\$607.20
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Yes

11/21/2014

FINISH: CAD PLATE PER QQ-P-416 TYPE II CLASS 2

PART ARE MADE FROM SHIM STOCK, C1095 BLUE TEMPERED SPRING STEEL

SP15-01-29

Line Total: \$607.20

4	123143	646.3912 SHIM	11/21/2014	50.00		\$6.60	\$330.00
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Yes

11/21/2014

FINISH: CAD PLATE PER QQ-P-416 TYPE II CLASS 2

PART ARE MADE FROM SHIM STOCK, C1095 BLUE TEMPERED SPRING STEEL

Line Total: \$330.00

5	123530	646.3912 SHIM	11/21/2014	50.00		\$6.60	\$330.00
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Yes

11/21/2014

FINISH: CAD PLATE PER QQ-P-416 TYPE II CLASS 2

PART ARE MADE FROM SHIM STOCK, C1095 BLUE TEMPERED SPRING STEEL

Note:

11/5/2014

Packing Slip



Cadorath Coating

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

S74889

Sold To:

Dart Aerospace Ltd.
1270 Aberdeen St.

Hawksbury, ON K6A 1K7

ShipTo:

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #:	Date Received:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
26392	Nov-15-2014	NET 30 DAYS	10071 6547 RT0001		Jan-28-2015

Item # Qty P/N & Description

1	4 EA	SHIM	S/N
		P/N 646.3913	W/O 140937
2	48 EA	SHIM	S/N
		P/N 646.3911	W/O 140938
3	92 EA	SHIM	S/N
		P/N 646.3913	W/O 140939
4	50 EA	SHIM	S/N
		P/N 646.3912	W/O 140940
5	50 EA	SHIM	S/N
		P/N 646.3912	W/O 140941
6	60 EA	SHIM	S/N
		P/N 646.3910	W/O 140942

126060 ✓ Sp 15-01-29

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Jan-28-2015

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 140939

INVOICE #: 74889

**CONTRACT OR
PURCHASE ORDER #** 26392

DESCRIPTION: SHIM

QTY

92 ✓

P/N # 646.3913 ✓

S/N #

SP 15-01-29

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector:



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☒</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☒	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☒																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15-03-04	140	10	while drilling Holes crack and makes big Burrs pland to drill RC. supplier		Scrap/destroy	DAS 38 9-89 MAR 04 2010	PD 15-03-04	PD 15-03-04
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator ☒									
Offset/Setup									
Process									
Supplier ☒									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☒ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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